

Date: Friday, 5/25/2007 8:36:36 AM  
 User: Kim Johnston

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: GAS SPRING - UNDER REVIEW	
Job Number	: 32644			LE 07.05.25	
Estimate Number	: 12702				
P.O. Number	: N/A		Part Number	: D35527	
This Issue	5/25/2007	S.O. No. : N/A	Drawing Number	: D3552 UNDER REVIEW LE 07.05.25	
Prsht Rev.	: NC		Project Number	: N/A	
First Issue	: N/A		Drawing Revision	: B	
Previous Run	: 31149		Material	: N/A	
Written By			Due Date	: 6/6/2007	
Checked & Approved By			Qty:		
Comment	: Est Rev: A New Issue 06-11-13 EC		20	Um:	Each

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	PG	PURCHASING
		 Comment: Issue P/O: 3839 Purchase Part Number: B6-220-530-70N Supplier: LS Technologies B6-220-530-070N Certificate of conformity is required LE 07.06.01
2.0	B822053070N	CARBON STEEL GAS SPRING
		 Comment: Qty.: 1.0000 Each(s)/Unit Total : 20.0000 Each(s) CARBON STEEL GAS SPRING
3.0	PACKAGING 1	PACKAGING RESOURCE #1
		 Comment: PACKAGING RESOURCE #1 Receive & Inspect For Transit Damage Ensure certificate of conformity is attached
4.0	QC6	DIMENSIONAL CHECK
		 Comment: DIMENSIONAL CHECK Test for correct pressure
5.0	PACKAGING 1	PACKAGING RESOURCE #1
		 Comment: PACKAGING RESOURCE #1 Identify and Stock Location:

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
07.06.01	1-0	change gas spring PIN to B6-220-530-070N on request from supplier - acceptable	LE	07.06.01	50	LE 07.06.01		

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes  No  DQA:  Date: 07/06/01  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
07/06/01	1-0							

NOTE: Date & initial all entries

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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: GAS SPRING - UNDER REVIEW

Job Number: 32644

Part Number: D35527

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 QC21

FINAL INSPECTION/W/O RELEASE



56

Comment: FINAL INSPECTION/W/O RELEASE

ND 07/26/07

Job Completion



u 07.06.07

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

**DART**

DESIGN <i>CE</i>	DRAWN BY <i>CE</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
CHECKED <i>PH</i>	APPROVED <i>TH</i>	DRAWING NO. D3552	REV. B	SHEET 1 OF 1
DATE 06.09.15		TITLE GAS SPRING	SCALE 1:1	

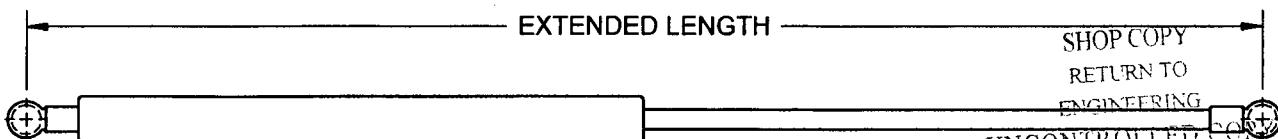
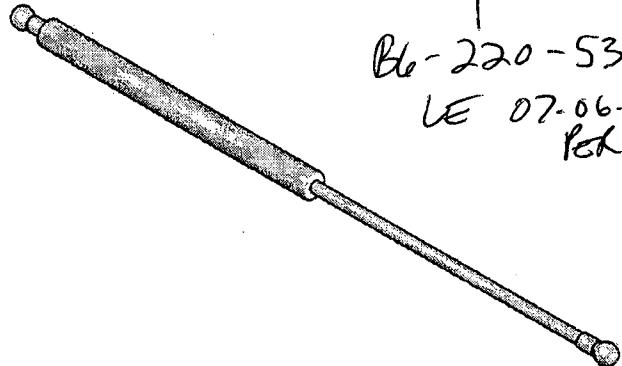
  

REV	DATE	DESCRIPTION
A	06.09.15	NEW ISSUE
B	06.10.24	ADD D-3552-7/-9; UPDATE DESC. D3552-1/-3/-5

## SPECIFICATION CONTROL DRAWING

**UNDER REVIEW***06.02.2013  
REV 001 P/L*

DART P/N	STROKE (mm)	EXTENDED LENGTH (mm)	FORCE (N)	END FITTING	MATERIAL	LS TECHNOLOGIES P/N
D3552-1	220	530	70	10 mm SS BALL SOCKET	CARBON STEEL	C8-220-530-70N
D3552-3	200	490	200	10 mm SS BALL SOCKET	CARBON STEEL	C8-200-490-200N
D3552-5	175	430	150	10 mm SS BALL SOCKET	CARBON STEEL	C8-175-430-150N
D3552-7	220	530	70	10 mm NYLON BALL SOCKET	CARBON STEEL	<del>B8-220-530-70N</del>
D3552-9	200	490	200	10 mm NYLON BALL SOCKET	CARBON STEEL	B8-200-490-200N

**D3552-X GAS SPRING**

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER NO. *32644*

**RELEASED**  
*06.12.22*

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## Certificate of Compliance

This is to certify that the merchandise listed below meets specifications as required by your order.

**50 Units: B6-220-530-070N CARBON STEEL GAS SPRING**

**This product is ROHS compliant**

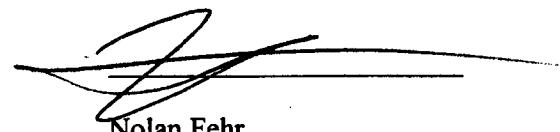
**We certify no mercury was used in the manufacture of this order.**

Order # PO00003839

LS Technologies Inv # 3750



L S Technologies Inc Canada

A handwritten signature in black ink, appearing to read "Nolan Fehr".

Nolan Fehr

LS Technologies Canada Inc.  
Box 25032  
Saskatoon, SK  
S7K 8B7

# Packing Slip

Date	Packing Slip #
6/13/2007	3750

Name / Address
Dart Aerospace Ltd 1270 Aberdeen St. Hawkesbury, ON K6A 1K7 Canada

Ship To
Dart Aerospace Ltd 1270 Aberdeen St. Hawkesbury, ON K6A 1K7 Canada

P.O. No.	Rep.	Ship Date	Ship Via
3839	Nolan	6/13/2007	Purolator

Qty	Description
50	B6-220-530-070N Carbon Steel Gas Spring Shipping and Handling PUROLATOR / DHL - Tracking #320365382656 Total GST Business Number: 875007718

*EPay/06/19*

Please remit to above address. Thank you for the business.